

Work Order ID 53810

November 18, 2009 12:47:32 PM

Page 1

Item ID: D3178-041

Accept

Revision ID: A

Item Name: Nut Plate

Start Date: 18/11/2009 Start Qty: 12.00

Required Date: 25/11/2009 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: PLDate: 07/11/18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3178

Rev A

100

0.00



Waterjet

FLOW CNC Waterjet

S65D
J63

Memo

CUT AS PER DWG

DWG REV: APROG REV: A

DEBURR

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

HB 9-12-10

EP 09/12/11 (28) (28)

HB 9-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53810

November 18, 2009 12:47:32 PM



Page 2

Item ID: D3178-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Nut Plate

Start Date: 18/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



=> 809/12/11

QC

Memo

0.00

Quality Control

counters
(X28)

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- C'sink D3178-1 holes as per Dwg D3178□2- Deburr

809/12/14 (28)

150

QC5- Inspect part completeness to step on W/O

0.00



=> 809/12/14

QC

Memo

0.00

Quality Control

counters
(X28)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53810

Page 3

November 18, 2009 12:47:32 PM

Item ID: D3178-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Nut Plate

Start Date: 18/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	UMP 09/12/16			X28			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	BR 09-12-16			(28)			
180 Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3178	0.00 0.00	GB 09/12/18			(28)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53810

November 18, 2009 12:47:32 PM



Page 4

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Setup Start



Revision ID: A

Stop



Item Name: Nut Plate

Start Date: 18/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



2) 802/12/18

QC

Memo

0.00

Quality Control

counted
(28) /

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/12/18 (28) SP

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/21 JF

C209/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 18, 2009 12:47:39 PM

Page 1

Work Order ID: 53810

Parent Item: D3178-041RevA

Parent Item Name: Nut Plate

Comments: IFP REV: B NOW ON WATERJET JLM VERIFIED BY:DD

Start Date: 18/11/2009

Required Date: 25/11/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21059L3 Nut Plate		Purchased	No			100	Each	276.0000	48.0000			

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	276	
	109962	11	
	111925	265	
MS052H32S.063 5052-H32 .063 Sheet		Purchased	No
		180	sf
		121.3237	0.4396

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	MAT	121.3237	
	103755	1.3237	
	107276	24	
	112442	96	
MS20426AD3-43 RIVET		Purchased	No
		180	Each
		7,861.000	96.0000

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	7861	
	104374	3861	
	110398	4000	

M7681 224

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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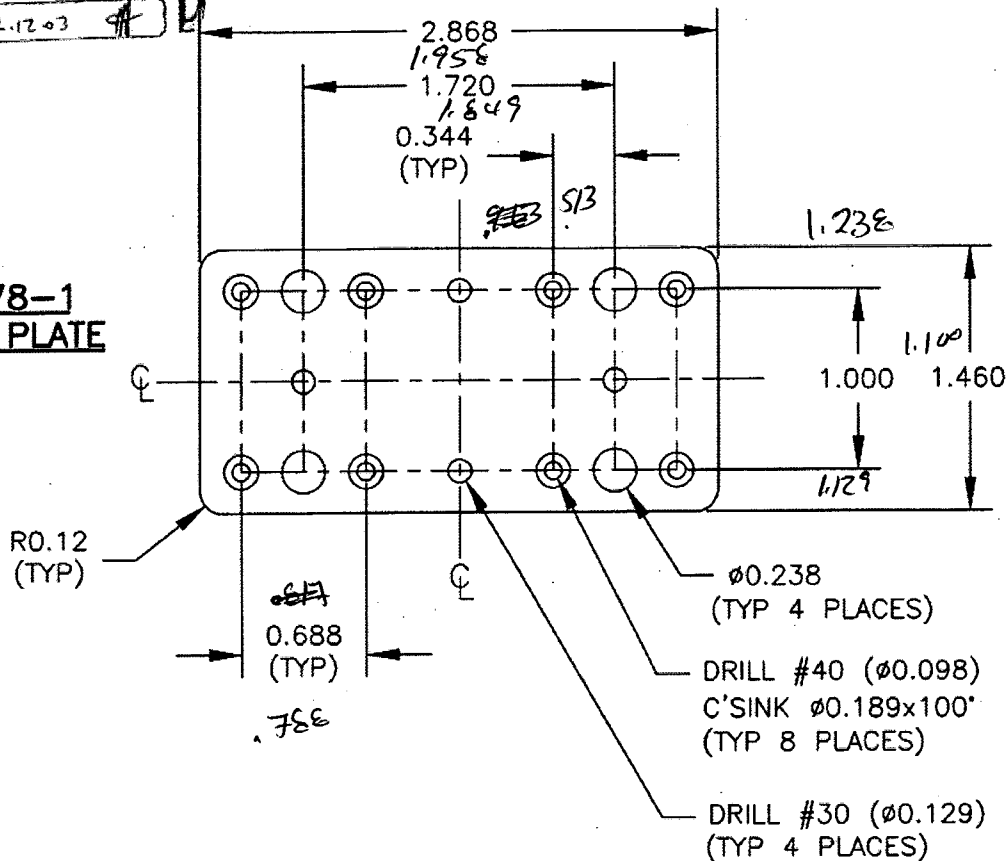
NOTE: Date & initial all entries

DART

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3178	REV. A SHEET 1 OF 1
DATE 02.12.03	TITLE NUT PLATE		SCALE 1:1
A	02.12.03	NEW ISSUE	

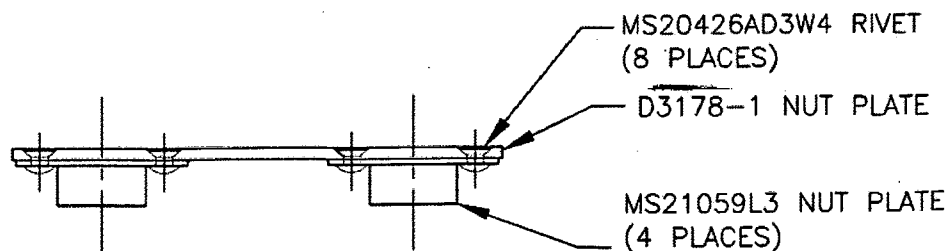
RELEASED
02.12.03

D3178-1 NUT PLATE



SHIPPING
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A CHANGE
WITHOUT NOTICE
WORK ORDER NO. 53810

D3178-041 NUT PLATE



NOTES, D3178-1 NUT PLATE:

- 1) PART IS SYMMETRIC ABOUT CENTERLINES
- 2) MATERIAL: 5052-H32/H34 SHEET 0.063 THICK (QQ-A-250/8)
(REF DART SPEC. M5052H32S.063)
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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